Work Order ID 65136

Thursday, January 06, 2011 3:28:09 PM

Item ID: D3953-9 **Accept**

Setup **Start** / **Stop**

Revision ID:

Item Name: Gas Spring Washer

Start Date: 1/6/2011 **Start Qty:** 12.00

Required Date: 1/14/2011 **Req'd Qty:** 12.00

Cust Item ID:

Customer:

Reference:

Run **Start** / **Stop**

Approvals: **Process Plan:** ___ **Date:** 11-01-7 **Tooling:** ___ **Date:** ___

QC: ___ **Date:** ___ **SPC (Y/N):** ___ **Date:** ___

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3953	C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Hardinge Hardinge CNC Lathe Small	**Memo** TURN AS PER FOLIO FA855 & DWG FOLIO REV: C DWG REV: ___ DEBURR	0.00 0.00				17	Ø		
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				17	Ø		

11/1/14

11/1/14

Work Order ID 65136

Thursday, January 06, 2011 3:28:09 PM

Item ID: D3953-9 **Accept**

Setup Start / Stop

Revision ID:

Item Name: Gas Spring Washer

Start Date: 1/6/2011 **Start Qty:** 12.00

Required Date: 1/14/2011 **Req'd Qty:** 12.00

Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	11/01/14			17	0		
130 Packaging Packaging	Identify as per dwg & Stock Location: 096 **Memo**	0.00 0.00					11/01/14		17
140 QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00					11/01/14		

11.01.14

Picklist Print

Thursday, January 06, 2011 3:28:14 PM

Work Order ID: 65136

Parent Item: D3953-9

Parent Item Name: Gas Spring Washer

Start Date: 1/6/2011 **Required Date:** 1/14/2011

Start Qty: 12.00 **Required Qty:** 12.00

Comments: IPP RevA: New issue 09.10.13 DD verified by:EC IPP Rev:B
as per dwg revC DD 10.03.02 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750 Delrin Round Bar 0.75"		Purchased	No			100	f	103.8970	0.05	0.631579		11/1/14	

Location	Loc Qty	Loc Code	
MAT	49.35		
116183	49.35		- 6 ft
MAT050	54.547		
112418	0.12		
115472	54.427		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	65136
Description: Washer	Part Number:	A3953-9
Inspection Dwg: A3953 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

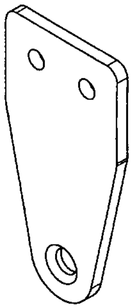
[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.63	±.030	Ø.629	✓		Vern	SA-9
Ø.257	+.010 / -.000	Ø.257	✓			
.05	+.030/-.000	.065	✓			

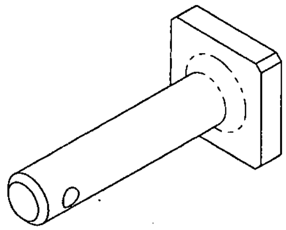
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Date:	11/1/14	Date:	11/01/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

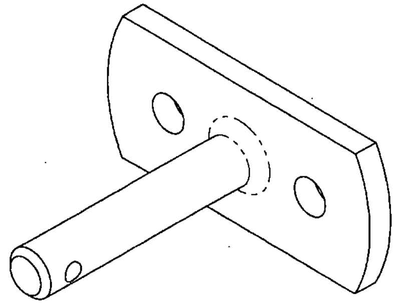
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65136
PS11-01-7



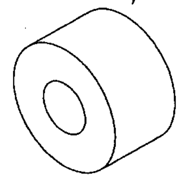
D3953-1 GAS SPRING BRACKET
(FULL LID)



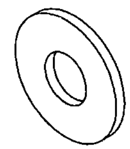
D3953-3 GAS SPRING STUD, LID



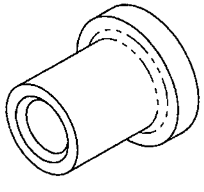
D3953-5 GAS SPRING STUD, BASE



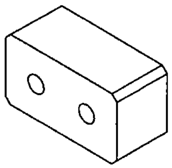
D3953-7 GAS SPRING SPACER



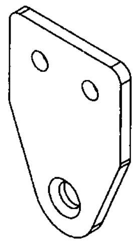
D3953-9 GAS SPRING WASHER



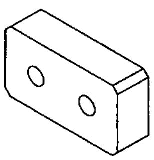
D3953-11 GAS SPRING SPACER



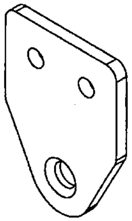
D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)

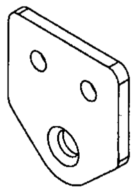


D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)
C

RELEASED 2010-02-26



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)
C

REV.	DESCRIPTION	BY	DATE
C	PARTS -19 & -21 ADDED (SHT 1& 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); ℄ SYMM WAS ℄ SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED	[signature]	DRAWING NO. D3953 — REV. C — SHEET 1 OF 4
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE: GAS SPRING LID COMPONENTS — SCALE: NTS
DE APPR.	[signature]	
DATE	10.01.29	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

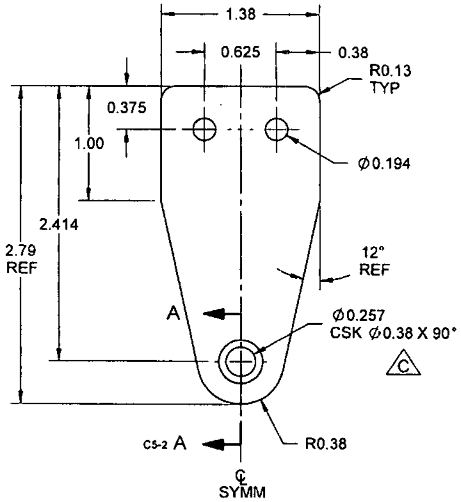
Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

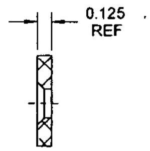
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

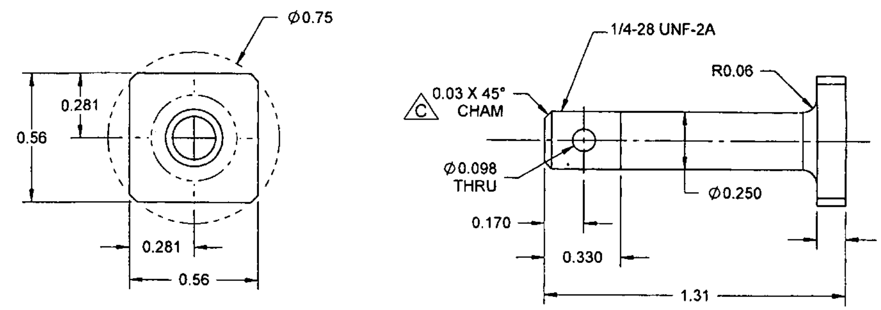
w/o 65136



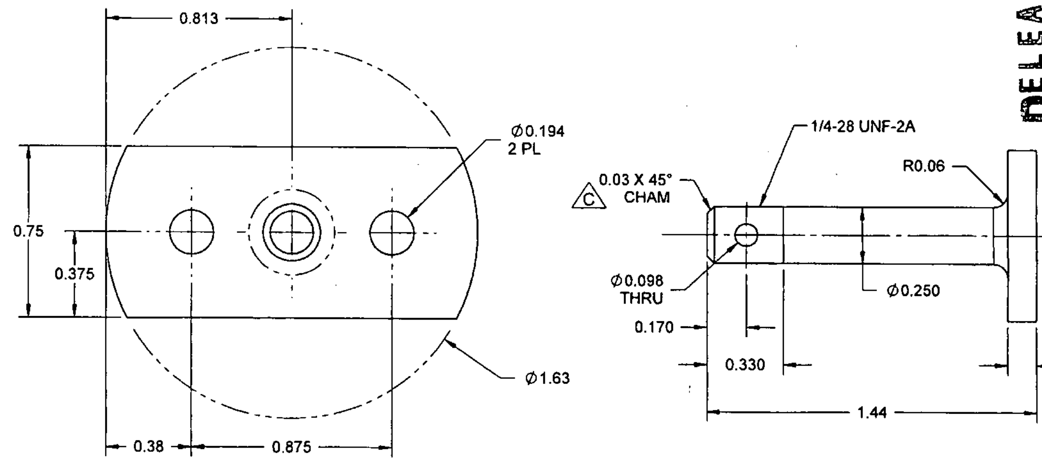
D3953-1 GAS SPRING BRACKET
(FULL LID)



SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE

RELEASED 2010-02-26

NOTES:
1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA

-3 & -5: AISI 304 STAINLESS STEEL BAR REF DART SPEC M304B
OR:
AISI 304/316 STAINLESS STEEL ROD REF DART SPEC M304R

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.11 lbs
-3: 0.03 lbs
-5: 0.06 lbs

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED	[signature]	DRAWING NO. D3953 REV. C SHEET 2 OF 4
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE GAS SPRING LID COMPONENTS SCALE NTS
DE APPR.	[signature]	
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

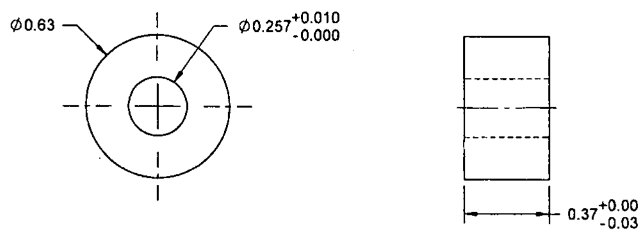
Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

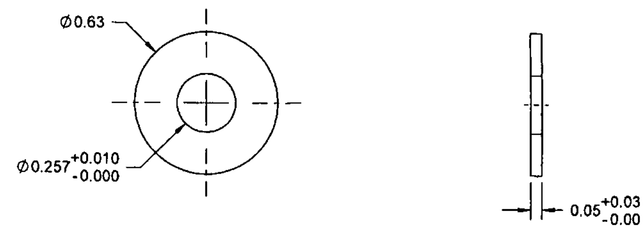
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

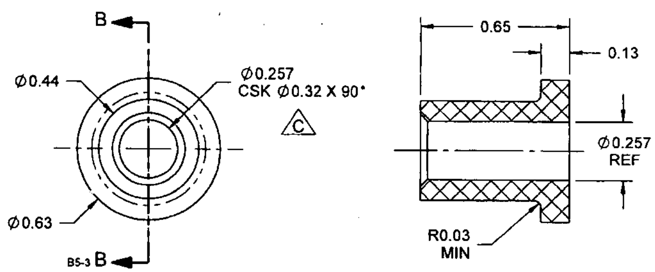
w/065136



D3953-7 GAS SPRING SPACER

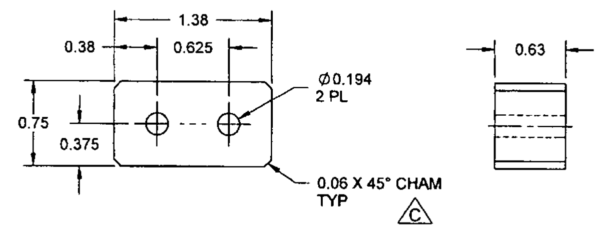


D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

SECTION B-B B7-3



D3953-13 GAS SPRING SPACER

RELEASED 2010-02-26

NOTES:
1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
-13: 0.17 lbs

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED	[initials]	DRAWING NO. D3953 — REV. C — SHEET 3 OF 4
MFG. APPR.	[initials]	
APPROVED	[initials]	TITLE: GAS SPRING LID COMPONENTS — SCALE: NTS
DE APPR.	[initials]	
DATE	10.01.29	

Dart Aerospace Ltd

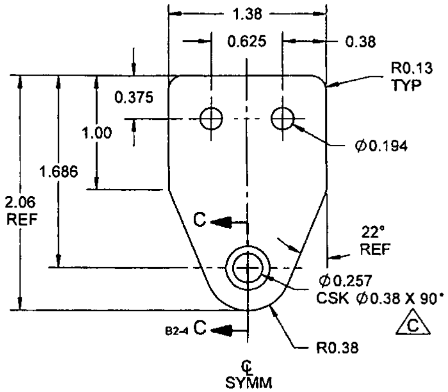
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _______

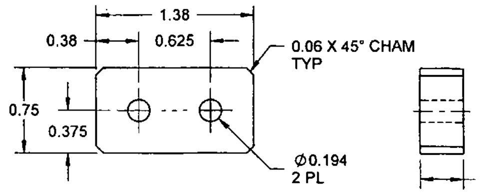
Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** _______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

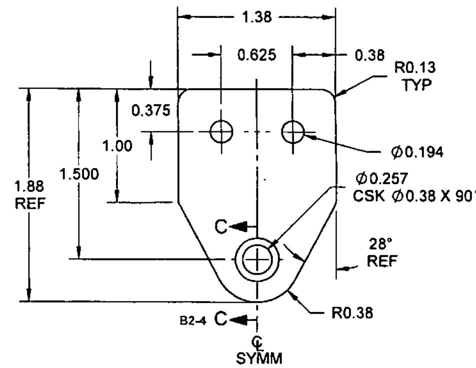
NOTE: Date & initial all entries



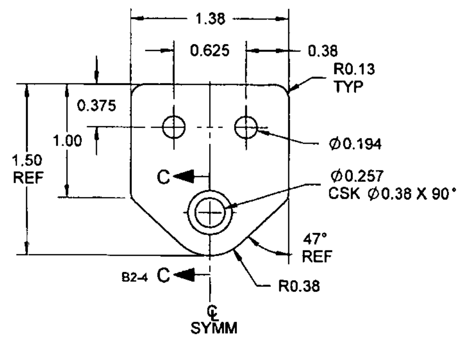
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



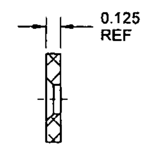
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)
C



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)
C



SECTION C-C C7-4 C2-4 B4-4
C

RELEASED 2010-02-26

NOTES:
1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs C

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3953 — REV. C — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE: GAS SPRING LID COMPONENTS — SCALE NTS
DE APPR.		
DATE	10.01.29	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ________________ **Disposition:** ________________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries